

Wednesday, 5/16/2007 1:40:46 PM
Kim Johnston

Process Sheet

23

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FLOAT WEB		
Job Number	32405		Part Number	D3282041		
Estimate Number	10791		Drawing Number	D3282 REV C		
P.O. Number	N/A		Project Number	N/A		
This Issue	5/16/2007	S.O. No.	N/A	Drawing Revision	C	
Prsht Rev.	NC		Material	N/A		
First Issue	N/A		Due Date	6/3/2007		
Previous Run	31930		Qty:	10	Um:	Each
Written By			Comment	Est Rev.B 05.09.23 Procedure change KJ/JLM		
Checked & Approved By						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2792130	EXTRUSION	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
	1 D2792-130 Extrusion	D24030	7-5-23
		Identify as D3282-1	
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	
		Cut to length as per Dwg D3282.	7-5-23
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	PTC
		1-Machine as per Folio FA579 & Dwg D3282	
		2-Deburr	SD/
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SP/
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	EN 07/05/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3282-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/06	3.0	I web was found to be twisted when it was installed in the HAAS. R.C. Came in from the supplier or was twisted during shipment.	<input checked="" type="checkbox"/> QSI042	Web is scrapped, use for tooling. I.D. web as "Tooling" use only ?	<input checked="" type="checkbox"/> 07/06/06	<input checked="" type="checkbox"/> 07/06/06	<input checked="" type="checkbox"/> QSI042	<input checked="" type="checkbox"/> 07/06/06

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:40:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 32405

Part Number: D3282041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

K

7-6-6

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

7-6-6

8.0 D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

B 31942

K

7-6-6

9.0 MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total : 570.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M 100854

K

7-6-6

10.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3 M 103674

K

7-6-6

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP

7-6-6

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: U6

K

7-6-6

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:40:46 PM
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Drawing Name: FLOAT WEB

Job Number: 32405

Part Number: D3282041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(?)

Comment: FINAL INSPECTION/W/O RELEASE

15 May 07

Job Completion



15 May 07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32405
Description: Float Web	Part Number:	D3282-041
Inspection Dwg: D3282 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

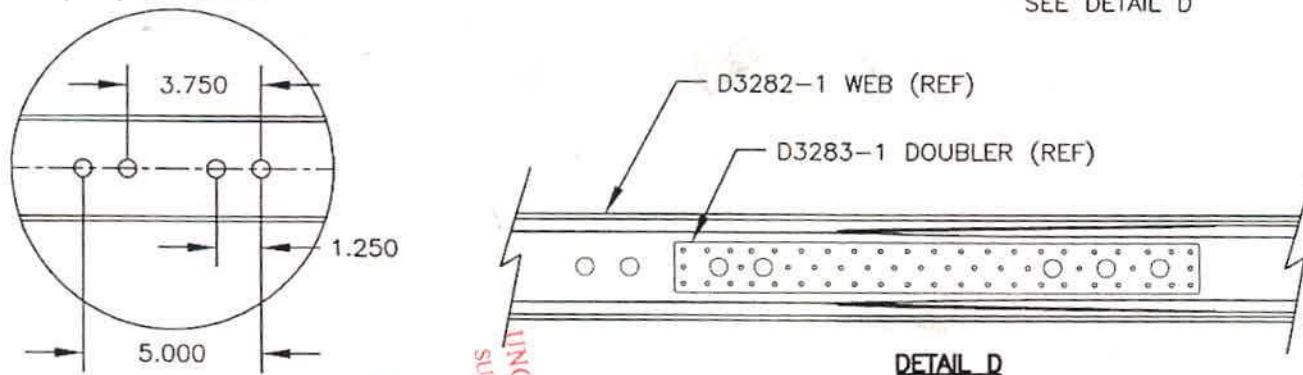
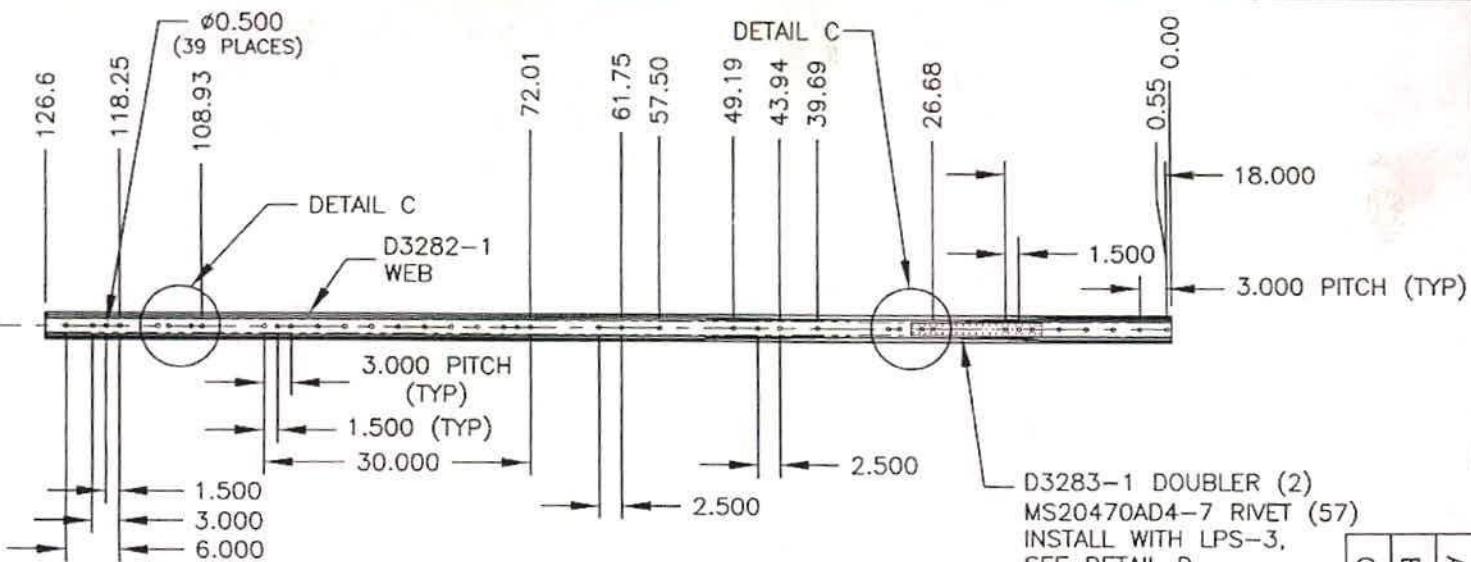
X First Article Prototype

Measured by:	<u>BG</u>	Audited by:	<u>JL</u>	Prototype Approval:	N/A
Date:	07-05-33	Date:	07/05/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HEDLOCK, WA	REV. C
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3282	SHEET 1 OF 2
DATE 05.08.09	TITLE FLOAT WEB, 206L/407	SCALE 1:20	
A 04.05.05	NEW ISSUE		
B 05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS		
C 05.08.09	REMOVE D3390-1, NOW MACHINED		



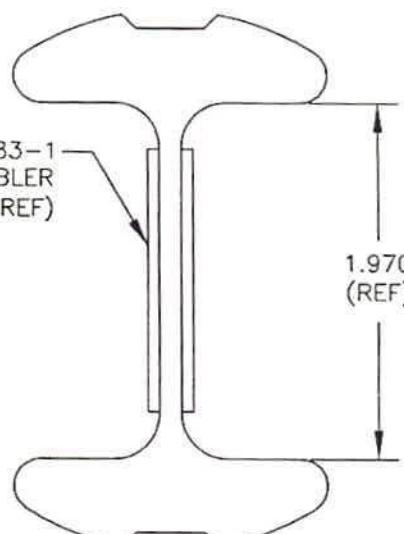
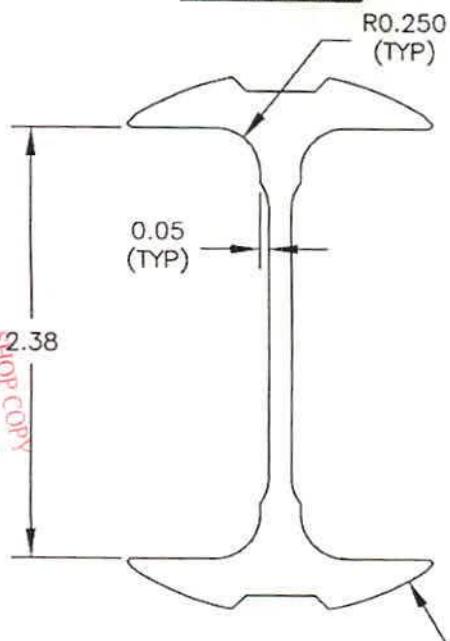
RELEASED
H
05.09.12

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

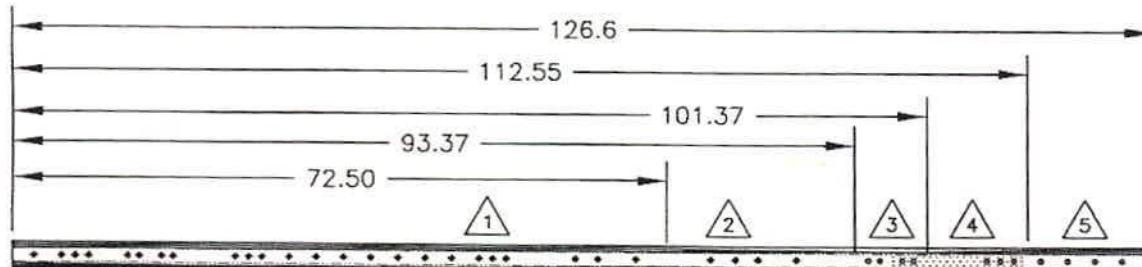
DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3282	REV. C
		TITLE	FLOAT WEB, 206L/407	SHEET 2 OF 2
		SCALE	1:20	

SECTION B-BD3283-1
DOUBLER
(REF)D2792-130
EXTRUSION
(REF)D2792-130
EXTRUSION
(REF)SECTION A-AR0.250
(TYP)0.05
(TYP)SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDERNO
32405

D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 ($\phi 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS

RELEASED
05-09-12